

Date: Wednesday, 6/27/2007 1:08:12 PM
User: Kim Johnston

Process Sheet

5

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CROSSBOLT SPACER
Job Number : 33214
Estimate Number : 11010
P.O. Number : N/A Part Number : D2649
This Issue : 6/27/2007 S.O. No. : NA Drawing Number : D2649 REV B1
Prsht Rev. : NC Project Number : N/A
First Issue : NA Type : MACHINED PARTS Drawing Revision : B1
Previous Run : 31926 Material : NA
Due Date : 7/25/2007 Qty: 1,000 Um: Each
Written By :
Checked & Approved By : 07.06.28
Comment : Est F 02:03.26 Added turning on Cobra NG

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6T0375W058 6061-T6 Tube .375 x.058W



Comment: Qty.: 0.2975 f(s)/Unit Total : 297.4650 f(s)
6061-T6 Tube .375 x.058W
Material: 6061-T6 or 5052-H32, 0.375" Dia X 0.058" Wall

07/07/29 104 897
Batch M 105042 (84) 24

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL
Machine as per folio _____ on cobra machine.

07/07/29 88

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

07/07/29 8.6 1003

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.F. 07/07/30 (1003)

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: BRANCLAY

07/11/31 (1000)

6.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/08/01

Job Completion



07/07/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

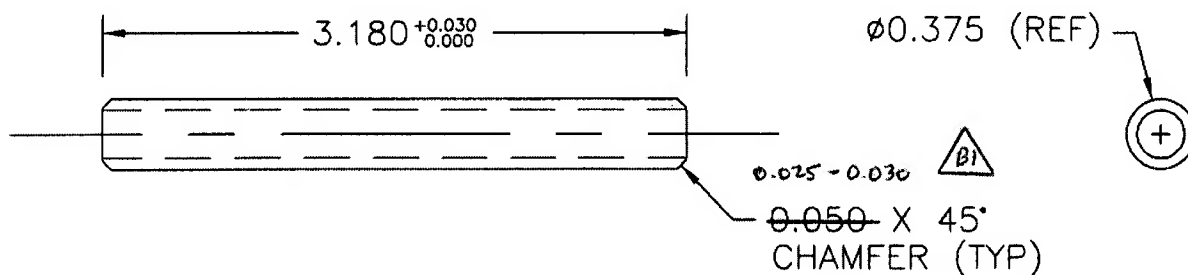
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>DM</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DM</i>	APPROVED <i>BW</i>	DRAWING NO. D2649	REV. B SHEET 1 OF 1
DATE 98.01.14		TITLE CROSS BOLT SPACER	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	98.01.14	3.180 WAS 3.230, ADD CHAMFER	
B1	# CP 02.06.13	REDUCE CHAMFER PER TSR 1296.	

RELEASED
98.01.20 DS



MATERIAL: 6061-T6 (WW-T-700/6) OR 5052-H32 (WW-T-700/4)
0.375 DIA 0.058 WALL

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
NOTED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
33214